

Thursday, January 30, 2014 2:06:20 PM

1 12608

RUSH
Feb 17th

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

10 mk.

Start Date: 2/6/2014 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 2/21/2014 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *WME*

Date: 14-1-30

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 Bandsaw Jeaspa Bandsaw	BAND SAW Memo Cut blank as per dwg PB67-43001	0.00 0.00				10	Ø		
110 Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE Memo 1- Mill as per Dwg B67-43001 DO NOT MILL 1.75" RAD 2- Deburr	0.00 0.00				10	Ø		
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				10	Ø		

Thursday, January 30, 2014 2:06:20 PM

1 12608

Item ID: PB67-43001-113

Accept

N900040100

Setup Start *NS1*

Item Name: Square Tube

Stop *NS2*

Start Date: 2/6/2014 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 2/21/2014 **Req'd Qty:** 4.00 ***/***

Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

Work Order ID 112608

Thursday, January 30, 2014 2:06:20 PM

112608

Page 3

Item ID: PB67-43001-113

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Square Tube

Stop ***NS2***

Start Date: 2/6/2014 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/21/2014 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>Memo</u>	0.00							
160									
Packaging	Memo	0.00				10X		14-2-12	DAS 26 9-89
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00						14-02-13	
Quality Control									

14-02-12

Picklist Print

Thursday, January 30, 2014 2:06:18 PM

Page 1

Work Order ID: 112608

Parent Item: PB67-43001-113

Parent Item Name: Square Tube

Start Date: 2/6/2014

Required Date: 2/21/2014

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.125		Purchased	No			100	f	129.7500	1.85	8			
6061T6 SQ TUBE 1.00 x 1.00 x .125w													

Location

Loc Qty

Loc Code

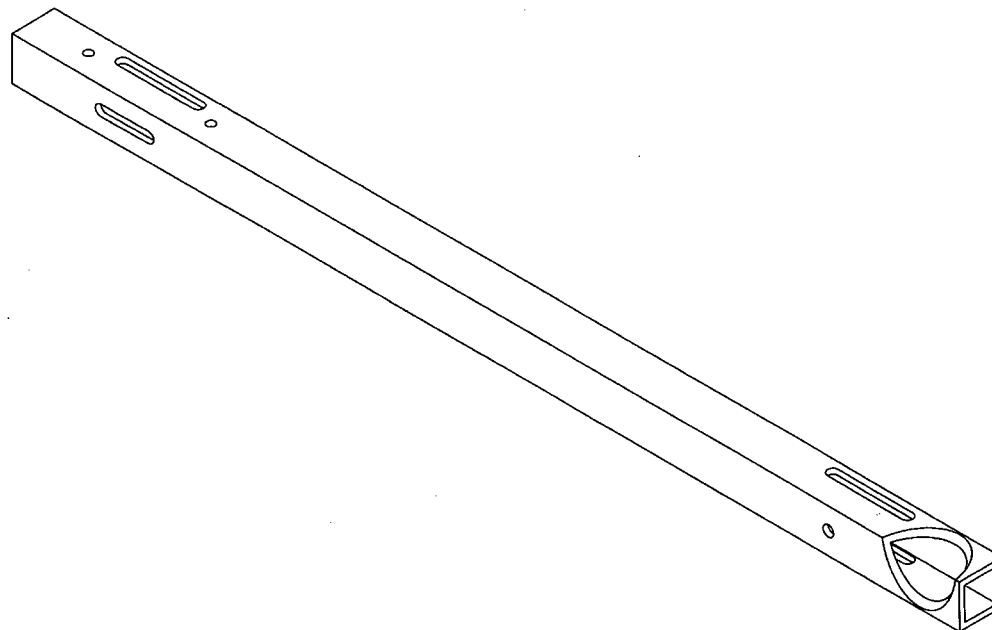
MAT

129.75

m128034

129.75

20' ~~129.75~~ FK 14/02/01



112608
mfc
14-1-30

B67-43001-113 SQUARE TUBE

RELEASED
2009-09-24
ND

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.89 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 33 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.18
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	<i>[Signature]</i>		REV. C	
MFG. APPR.	<i>[Signature]</i>		SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>		SCALE	
DE APPR.	N/A	SQUARE TUBE	NTS	
DATE	09.02.18		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

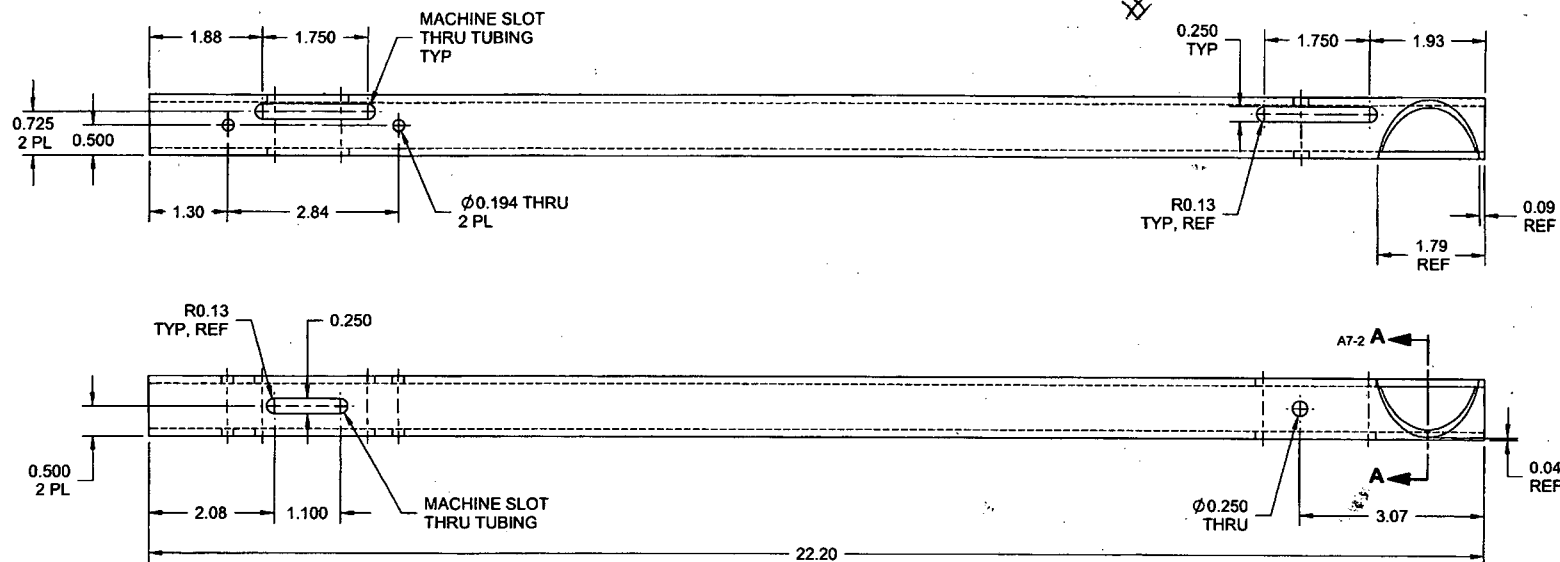
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

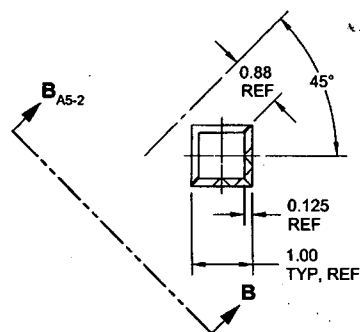
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

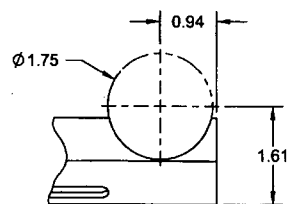
Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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B67-43001-113 SQUARE TUBE



SECTION A-A C2-2



VIEW B-B B8-2
ROTATED 45° CCW

RELEASED
2009-09-24

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	B	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	AW	B67-43001-113	SHEET 2 OF 2
APPROVED	AW	TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	09.02.18	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DART AEROSPACE LTD		Work Order: 112608
Description: Square Tube		Part Number: PB67-4301-113
Inspection Dwg: PB67-4301-113 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.88	+/- .030	1.88	/		FK-04	Vern.
1.750	+/- .010	1.755	/		"	"
.725	+/- .010	.725	/		"	"
.500	+/- .010	.499	/		"	"
1.30	+/- .030	1.301	/		"	"
2.84	+/- .030	2.84	/		"	"
Ø .194	+/- .005/- .001	.194	/		"	"
.250	+/- .010	.254	/		"	"
1.750	+/- .010	1.752	/		"	"
1.93	+/- .030	1.93	/		"	"
R.13	+/- .030	.125	/		R-G	ref.
1.79	+/- .030	1.793	✓		Vern	GA-01
.09	+/- .030	0.091	✓		"	"
.250	+/- .010	.251	/		FK-04	Vern
.500	+/- .010	.498	/		"	"
2.08	+/- .030	2.08	/		"	"
1.100	+/- .010	1.099	/		"	"
Ø .250	+ .005 / - .001	.251	/		"	"
3.07	+/- .030	3.071	/		"	"
.04	+/- .030	0.037	✓		Vern	GA-01
.88	+/- .030	—	—		—	—
45°	+/- .5°	45°	✓		A-M	CNC-02
1.00	+/- .030	1.00	/		FK-04	Vern-

Measured by: B.A	Audited by: [Signature]	Preliminary Approval:
Date: 14/02/14	Date: 14/02/12	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

